

Work Order ID 53901

November 23, 2009 1:24:21 PM



Page 1

Item ID:	D3827-041	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Rib Assembly (Inboard)					
Start Date:	23/11/2009	Start Qty: 6.00		Cust Item ID:		
Required Date:	27/11/2009	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>RA</u>	Date:	<u>09-11-23</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3827	Rev A								

100



Large Fab

Large Fab

Large Fab

Memo

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch: M109213

7- grind weld flush ✓

8- deburr if necessary ✓

0.00

0.00

SAD 09-11-25

SAD 09-11-25

SAD 09-11-25

SAD 09-11-25

SAD 09-11-25

SM 09/11/26

SM 09/11/26

(6)

(6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:	A				Stop	
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Start Date:	23/11/2009	Start Qty: 6.00		Cust Item ID:		
Required Date:	27/11/2009	Req'd Qty: 6.00		Customer:		
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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC Quality Control	Memo	0.00							PD 09.11.26 ⑥
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							PD 09.11.26
150 	Identify as per dwg & Stock Location: <u>Basket</u>	0.00							
Packaging Packaging	Memo	0.00							PD 09.11.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






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NOTE: Date & initial all entries


Work Order ID 53901

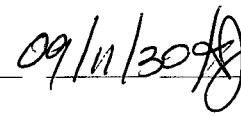
Page 3

November 23, 2009 1:24:21 PM

Item ID: D3827-041 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Rib Assembly (Inboard)
Start Date: 23/11/2009 Start Qty: 6.00  Cust Item ID:
Required Date: 27/11/2009 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

09/11/30 
R/09-11-27
(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 1:24:28 PM

Page 1

Work Order ID: 53901



Parent Item: D3827-041RevA



Parent Item Name: Rib Assembly (Inboard)

Start Date: 23/11/2009

Required Date: 27/11/2009

Comments: IPP RevA: revise process 0.9.11.11 DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1RevA		Manufactured	No			100	Each	36.0000	18.0000			

Bushing

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

WA

36

53442

36

100

f

682.7783

50.5263

18x 24/09/11/26

SFD 09-11-25

M304TS0.750W.065

Purchased

No



304 SQ Tube .75x.75x.065W

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

MAT

682.77829

113082

82.77829

113245

600

Main Warehouse

WA

0.0000047

112398

0.0000047

50.5263

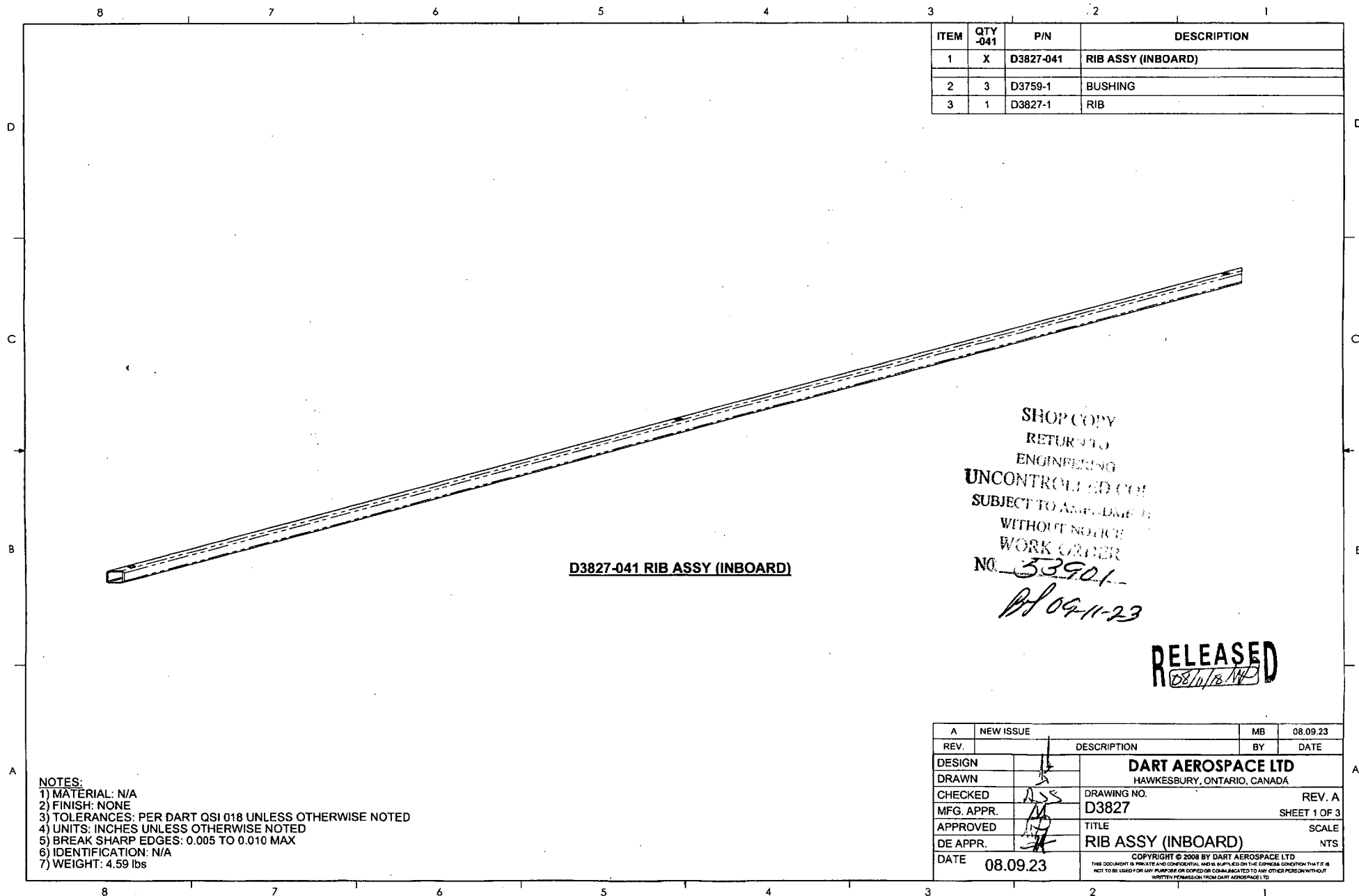
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 53901
 08/11/23

RELEASED
 08/11/23

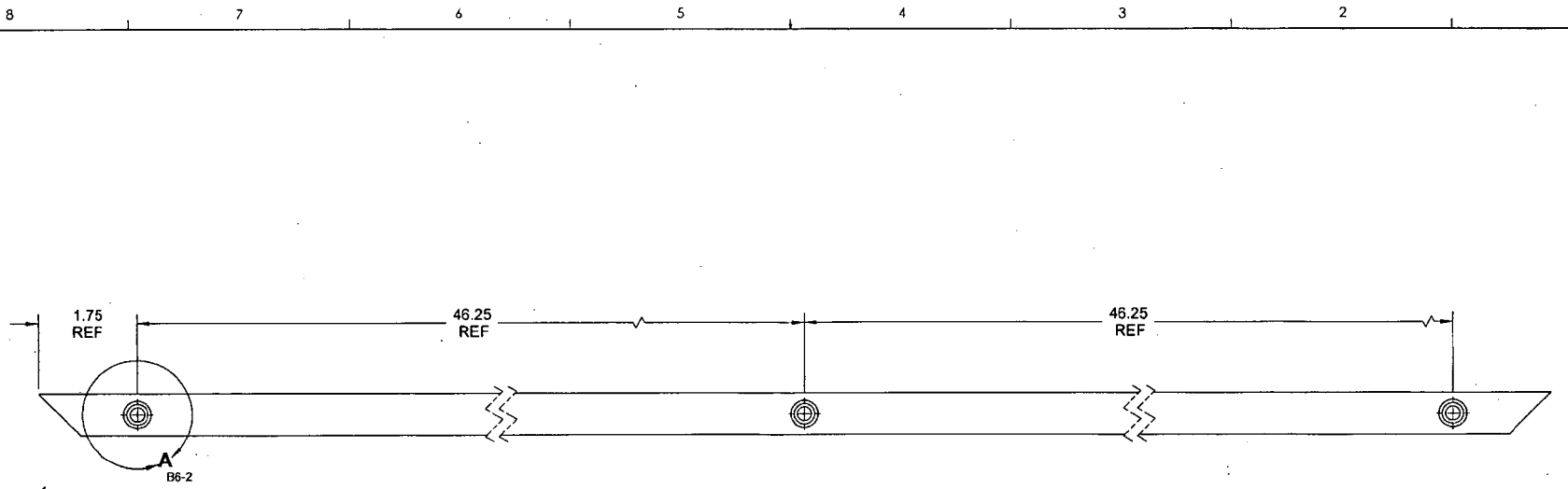
NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 4.59 lbs

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

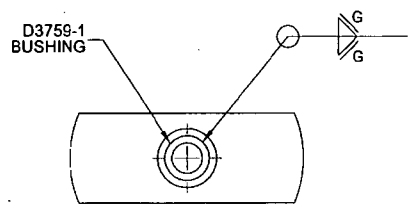
DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3827
 REV. A
 SHEET 1 OF 3
 TITLE RIB ASSY (INBOARD)
 SCALE NTS

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D3827-041 RIB ASSY (INBOARD)

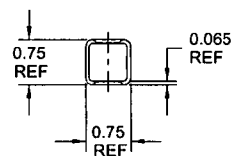
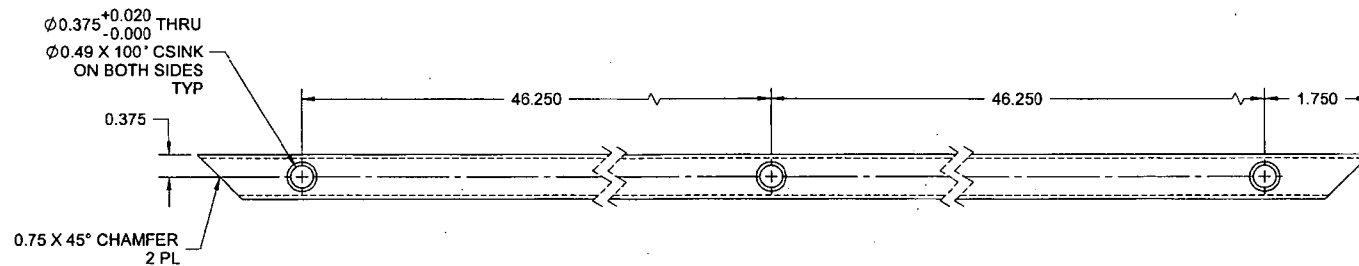


DETAIL A
SCALE 2X
C7-2
3 PL

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08/11/18

W10 53901

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 2 OF 3
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DE APPR.		RIB ASSY (INBOARD)	NTS
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D3827-1 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.55 lbs

RELEASED
08/11/23

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 3 OF 3
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